Work Ord February 27, 2				*97815*								
Item ID: Revision ID: Item Name:	D2230-3 Lug			Accept	*N900	04010)* s	Setup Start Stop	*NS			
Start Date: Required Date Reference:	2/27/13 e: 3/15/13	Start Qty: 100.00 Req'd Qty: 100.00			Cust Item : Customer:	ID: .						
Approvals:	Process Pla	an: CA	Date: 13/02/	Tooling:	D	ate:	F	Run Start	*NR	1*		
:	QC:		Date:	SPC (Y/N):		ate:		Stop	*NR	2*		
Wern Lence	٠٠٠	beser-plon		ser Sp. Run Moacs	OS THE	Dan I- Man - Mac	Accept Qty	•		ះក្. នេះមេ		
Draw Nbr	Rev	vision Nbr					,					
D2230	Rev	v G										
100				0.00			4 1	,	,			
100 Bandsaw Jeaspa Bandsaw		Meno Cut D2423 e Batch:	extrusion to 0.82"	0.00			(X	_13/0	2/27_			
110		فين	t@metec	0.00								
`*11 0 *		HAAS CNC VERTICAL	MACHINING #1	0.00			4	L 13/c	2/27	100		
HAAS I DOWN		FOLIO REV DWG REV:	er folio FA927 :ack while loading into the	0.00 machine.				<u> </u>	<u> </u>	100		
		Ć I	LOS PIOS	o motor	P10 19	194						

inser P10 to meter P10.19194 Muchine as parchey D2230 REO.G

					2							
					كمسر					DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ON	FORN	MANCE / UPI	DATE	•		
	es / ,10				198					QA Closed:	Date:	
Work Orde	r'		7. 7.		DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part N				***************************************	Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	NCR No				Use-as-is Work Order Update	~		Finishing Composite	Rec/Stor	re/Packaging Supplier	Other	
Root				Descri	ption of work order update	In	itial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling				Ì								
Operator				.	* *							
Material						Ì						
Setup												
Other												
Process		ļ										
Supplier		İ						,				
raining												
Jnapproved												
			g in	Jen ere	F	AULT	CATE	GORY	\$,711 u		٧	sk s
. Landin	g Gear	-	Omean	itiya	General	<u>~</u>		"是一个"是 寶寶斯	Land Miles	The following	Breach Street	
	Bending				Bend	Ш	Grain			Ovalized		Pressure/Forced
	Centre No	ot Concei	ntric to	o/s	BOM/Route		Iardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	<u></u> "	nspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	∐"	nstruct	ions Incomplete/	Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs				Contamination		√lainte	nance		Part Moved		
	Heat Trea	at		[Countersink		∕Iislabe	led		Positioned V		_
	Inspection	n Strip in	Tube		Cut Too Short		∕lisreac	i		Power Loss/	'Surge	Other
					Drill Holes	Offset			-			

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Hand Finishing

	DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	
Work Orde	r·	-	23.1		DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	0				Rework Scrap Use-as-is Work Order Update	I	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	<u> </u>	ī	T	Descri	ption of work order update	Initial	Δ	Action	Sign &	79	
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	ļ.			Verification	QCInspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training		3.00	dy		or Horr comormance	Cities Elig			Date		93 37
Unapproved	-		<u> </u>			AULT CATE	GORY.		<u> </u>	L	
Landin	g Goor			**	General	AOLI CAIL		,			. 2+
Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Instruc Maint Mislab Misrea Offset Out of	tion Incomplete tions Incomplete enance eled		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \ Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	Wave/Tw				Folio	 -	e Dimensions				

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Work Ord February 27, 20				*97815*								
Item ID: Revision ID: Item Name:	D2230-3			Accept	*N900	040	100)* ፡	Setup Start Stop	*NS1* *NS2*		
Start Date: Required Date Reference:	2/27/13 : 3/15/13	Start Qty: 100.00 Req'd Qty: 100.00	*10 *10		Cust Item l Customer:	ID:						
Approvals:		lan:	Date:			ate:		1	Run Start Stop	*NR1* *NR2*		
Sequence ID/ Work Center I 160 *160* QC Quality Control	D	Operation Description QC7-Inspect Chemical Co Memo	Set Up/ Run Ho onversion Coat 0.00		Too!ID	Tool#	Plan Code	Accept Qty	Qty	Reject Insp. Number Stamp		
170 Powdercoat Powder Coating		White Gloss(Ref:4.3.5.1) r Memo START TIME OVEN TEMP FINISH TIME	1 J4 J47 : 2 <u>30 </u>	0.00				100	of B	13-3-13.		
180 *180* QC Quality Control		QC3- Inspect Part Finish Memo		0.00 3	s 19		(100 Cous				

								DQA:	Date:					
NCR: Yes	/ No			WORK ORDER NON-	CONFOR	MANCE / UP		QA Closed:	Date:					
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No.				Rework Scrap Use-as-is Work Order Update	Scrap Machining Sm Use-as-is Thermoforming Fi				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
Root				Description of work order update	Initial	Ac	tion	Sign &						
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector				
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training														

2.0	Landin	g Gear _{ळ अ} ्राह्म दुर्भ र ३ ५ अस		General		· 物資本的 表示性質	Plas			_ **
		Bending		Bend	Γ	Grain		Ovalized	L	Pressure/Forced
	Γ	Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure
		Cracks	Г	Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld
		Crushed/Crimped.	Г	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled
•	Γ	Cuffs		Contamination		Maintenance		Part Moved		
j	Γ	Heat Treat		Countersink		Mislabeled		Positioned Wrong		-
	Γ	Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge		Other
		Ripples in Bend		Drill Holes		Offset				
		Torque Waves in Extrusion		Drawing		Out of Calibration				
		Turning Sequence		Finish		Out of Sequence		1		·····
	Γ	Wave/Twist in Tube		Folio		Outside Dimensions				

FAULT CATEGORY

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+

Unapproved

	Work Order ID 97815 Shruary 27, 2013 10:11:10 AM				*978	815*				Page 4		
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D2230-3 Lug 2/27/13 3/15/13	Start Qty: 100.00 Req'd Qty: 100.00			cept	*N900040100 Cust Item ID: Customer:)* s	Setup Start Stop		NS1* NS2*
Approvals:	Process P QC:	lan:	Date:		ooling: _		ite:		R		tart *	NR1* NR2*
Sequence ID/ Work Center II 190 *100* Packaging Packaging	- ·	Operation Description Identify as per dwg & Stoo	k Location:	<u>J</u> 469	Set Up/ Run Hours 0.00	Tesi ID	Tool#	Plan Code	Accept Qty	Reject Qty	Rejec Num	
200 * 2 00* QC		QC21- Final Inspection - \ ; Memo	Work Order Rele	ease	0.00	,•			1 The Control of the		3/4	13 A

Quality Control

M13-02/3

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	•							-		QA Closed:	Date:	
Work Orde	or.				DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	
VVOIR OIGE				· · · · · ·	Rework	1 	Skid-tu	be	Crosstube	1	Water Jet	Engineering
Part N	lo.				Scrap	1	Machini	—	Small Fab	Pro	d. Eng. Coor.	Quality
1 01111		_ _ .			Use-as-is	The	Thermoforming Finishing			⊣	e/Packaging	Other
NCR N	lo.				Work Order Update	1	Large F	·	Composite	1	Supplier	
						<u> </u>						
Root				Descri	ption of work order update	Initia	Initial Action			Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief E	ng	Desc	cription	Date	Verification	QC Inspector
Doc/Data										i		
Equip/Tooling												
Operator												
Material												
Setup												
Other [
Process [!		
Supplier												
Training							ļ					
Unapproved		<u> </u>										
					F	AULT CA	TEGORY			1		
Landir	ng Gear			-; \$2 <u>14.</u>	General General						_	-
	Bending				Bend	Grai	n		_	Ovalized	L	Pressure/Forced
	Centre No	ot Conce	ntric to (D/S	BOM/Route	Hard	lware			Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ection Incor	mplete	_	Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Instr	uctions Inc	omplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs Contamination				Mai	ntenance			Part Moved			
[Heat Treat Countersink				Misl	abeled			Positioned V	Vrong		
	Inspection Strip in Tube Cut Too Short				Misr	ead			Power Loss/	Surge	Other	
	Ripples in Bend Drill Holes				Offset							
[Torque Waves in Extrusion Drawing				Out of Calibration							
[Turning Sequence Finish				Out of Sequence					· · · · · · · · · · · · · · · · · · ·		
	Wave/Twist in Tube Folio			Folio	Outside Dimensions				1			

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Picklist Print

February 27, 2013 10:11:10 AM

Work Order ID:

97815

Parent Item:

D2230-3

Parent Item Name:

Lug

Start Date: 2/27/13

Required Date: 3/15/13

Start Qty: 100.00

Required Qty: 100.00

Comments:

IPP D00.05.18Added inspection level 8, and removed P/O for powder

coatEC

IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED

BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P LUG		Purchased	No				Each	0.0000		100	/	13/3/	10/15
D2423 Lug Extrusion		Manufactured	No			100	f	679.3700	0.0683	7.1894737	213	1021	2)
isug iskuukton				Location		Loc Qty	<u>Lo</u>	c Code	-			- 3	
				MAT006		383							•
				4372	2	161.5							
				8795	3	221.5				-,			
				Metec		296.37							
				9355	1	296.37				7.17			

Page 1

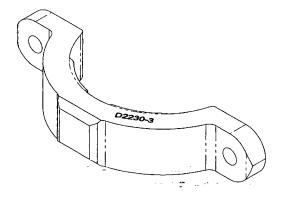
		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
		QA Closed:	Date:	

									QA Closed:	Date.			
Work Order: DISPOSITION							AGAINST DEPARTMENT/PROCESS						
Part No.				Rework Scrap	4 1	Skid-tube Machining	Crosstube Small Fab	}	Water Jet	Engineering Quality			
NCR No.			Use-as-is Work Order Update	Thern	noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other				
Root				Descri	ption of work order update	Initial	Act	ion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector		
Doc/Data													
Equip/Tooling					•				,				
Operator	_												
Material									ı				
Setup	_												
Other	_								,				
Process	_								ļ				
Supplier	_								-				
Training	_												
Unapproved						AULT CATE	CORV						
Landin		<u></u> .				AUL! CATE	GORT						
: Landin	Bending		٠ ٠	· ``\—	Bend	Grain			Ovalized		Pressure/Forced		
-		nt Concer		 -	BOM/Route	Hardwa	are	<u> </u>	Over/Under	tolerance	Temperature/Cure		
-	Cracks	- h		Broken/Damaged		ion Incomplete		Part Incorre	<u> </u>	Weld			
-		Crushed/Crimped. Burrs			Instructions Incomplete/Unclear		Part Lost/M	<u> </u>	Wrong Stock Pulled				
<u> </u>	Cuffs Contamination		Mainte	,		Part Moved							
F	Heat Treat Countersink		Mislabe			Positioned V							
	├ ─		Cut Too Short	Misrea	d		Power Loss/	Surge	Other				
ľ	Ripples in Bend Drill Holes			-	Offset			<u>-</u> 					
	Torque W		xtrusion	ı	Drawing	Out of	Out of Calibration						
	Turning S				Finish	Out of	Sequence		!				
<u> </u>	Wave/Twist in Tube Folio			Folio	Outside Dimensions								

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D2230-1

D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

CX13/02/27 W10:978/5



DRAWN	1	AJ K S	HAWKESBURY, ONTARI	O, CANAI	ΟΑ ,
DESIGN BW		вуу	DART AEROSPA	CE LI	D :
REV.			BY	DATE	
С	RE-DES	IGN		BW	94.03.30
D	RE-DES	IGN	BW	95.01.04	
E	RE-DES	IGN	BW	95.01.04	
F	REDESI	GN; R1.200 WA	CP	99.12.13	
G	STAND	WN IN SOLIDW ARDS, REFER TO PREVENT ("ATION.	AJS	09.01.16	

DRAWN	AJIO	HAWKESBURY, ONTARIO	, CANADA ,	
CHECKED	1	DRAWING NO.	REV. G	
MFG. APPR.	C/ml.	D2230	SHEET 1 OF 3	
APPROVED	M	TITLE	SCALE	
DE APPR.	'-t	MOUNTING LUG	NTS	
DATE 09.0	01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONTRICTION AND IS SUPPLIED ON THE EXPRESS CONDITION THA! IT IS NOT TO BE USED FOR ANY PERPOSE ON COMPANION ET DE ANY THOUT		

<u>a</u>

D

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ±0.005.
7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

D

С

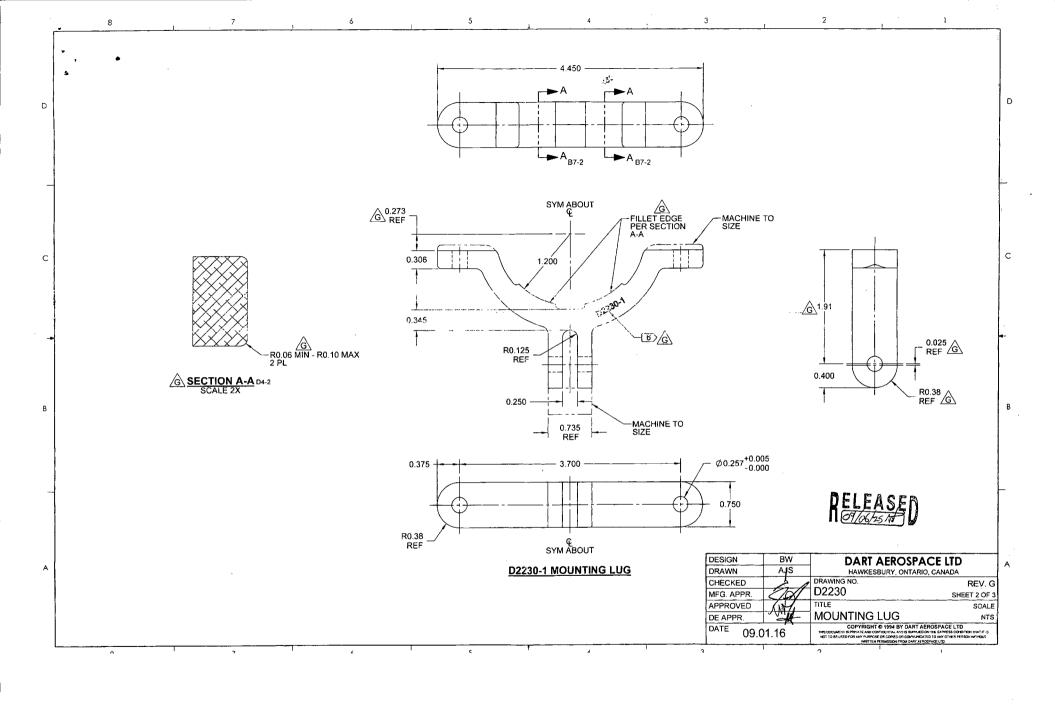
В

NCR:	Yes /	No

DQA: _____Date: ____

NCR: Y	'es	/ No				WORK ORDER NON-C	JOI	NFORIN	MANCE / UPL	JAIE	QA Closed:	Date:	
DISPOSITION									AGAINST DE	PARTMENT/	PROCESS		
Work Order: Part No.				Rework Scrap	Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor.		Engineering Quality			
NCR No.			Use-as-is Work Order Update		Thermoforming Finishing Large Fab Composite			Rec/Stor	e/Packaging Supplier	Other			
Root					Descr	iption of work order update	1	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification_	QC Inspector
oc/Data quip/Tooling	_	:									,		
perator	\neg												
1aterial													
etup [\Box										'		
ther	╝						ł						
rocess	\Box			·							,		
upplier	_												
raining	_										,		
napproved			1				<u> </u>	T CATE	CORV				
Landir	~ 6			1-01 000		Generál ⁽⁴²	AUL	CATE	JURT	•:		· · · · · · · · · · · · · · · · · · ·	
Landi		Bending			Г	Bend	Г	Grain			Ovalized		Pressure/Forced
⁵		Centre No			_{0/s} -	BOM/Route	\vdash	Hardwa	re		Over/Under	tolerance	Temperature/Cure
ŀ	_	Cracks			' -	Broken/Damaged			on Incomplete	<u> </u>	Part Incorrect		Weld
ŀ	-	Crushed/0	Crimped,			Burrs		1	ions Incomplete/U	Jnclear	Part Lost/Mi	<u> </u>	Wrong Stock Pulled
ļ		Cuffs	,			Contamination		Mainte			Part Moved		-
Ī	Heat Treat Countersink				Mislabe	eled		Positioned V	Vrong	_			
Ī		Inspection	n Strip in	Tube		Cut Too Short		Misreac	i		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	aves in E	xtrusion		Drawing		Out of 0	Calibration				
		Turning Se	equence			Finish	L	Out of S	Sequence		1		
	Wave/Twist in Tube Folio					Outside Dimensions							

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		DQA:	Date:	
ICD: Van / Na	MODE ODDED NON-CONFORMANCE / LIDDATE		-	

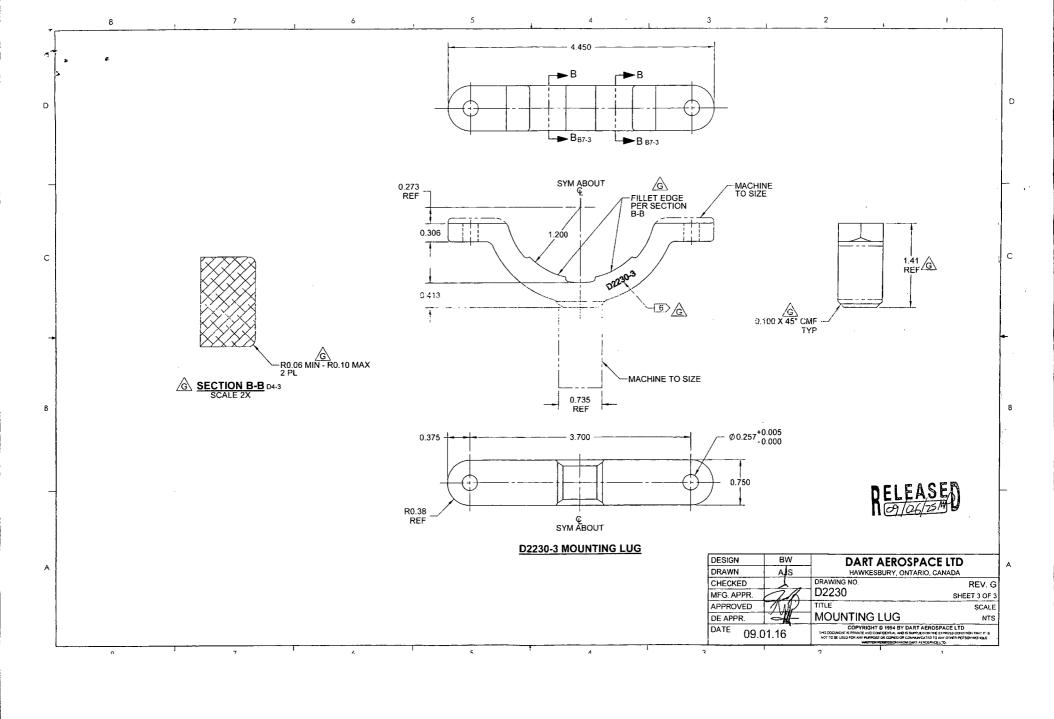
NCR:	Yes	/ No				WORK ORDER NON-	CONF	ORN	/ANCE / UPC	DATE	QA Closed:	Date	:
Work Ord	er: _					DISPOSITION Rework	7	AGAINST DEPARTMENT/PROCESS Skid-tube Crosstube Water Jet Engineering					
Part No.				Scrap Machining Sn Use-as-is Thermoforming Fi		Crosstube Small Fab Finishing Composite	Prod. Eng. Coor. Quality Rec/Store/Packaging Other		Quality				
				T				. , 7		:	Cian 9		
Root Cause		Date	Step	Qty	i	ption of work order update or Non-conformance	Init Chief	- 1	Act Descr	ion iption	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training													
Unapproved		.,	l	L		F	AULT (CATE	GORY		<u> </u>	<u>.</u>	
Landi	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Halins Ins	struct ainte islabe isread fset ut of C	re ion Incomplete ions Incomplete/U enance eled	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		

Outside Dimensions

Wave/Twist in Tube

Folio

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20 Terry Fox Drive Vankleek Hill, Ontario K0B 1R0 , Canada

Tel: (613) 678-3957 Fax: (613) 678-3956

Shipped By:

Delivery Slip N

Date: Page: 8982

Mar 07, 2013

Sold to:	Ship to:	
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lace le 1270 Aberdeer Stree Hawkesbury, Chtarid K6A 1K7	
Order No.: 19194	Sold By: Dewart Eric	
Shipped By: your truck	Ship Date: Mar 08, 2013	

Description	Unit	O 9	red uity	Shipped quantity	Backorder quantity
D2731-7 LUG as per drawing D2731 REV. C B93551	Each		44)	40	
D4091-1 Lug as per drawing D4091 Rev.A B93551	Each		44	40	
D2230-1 Mounting Lug as per drawing D2230 REV. G B93551	Each		z do	200	
D2230=3 Mounting Lug as per drawing D2230 REV. G B93551	Each		r c o	100	
,					
The delivered goods must be inspected upon receipt to confirm compliance.					
Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
		-			
Received by	Thanl	k ya	or y	ur order!	



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0 Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@mete...d

CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont.

same

K6A 1K7

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
40	D2731-7	Lug	PO 19194
40	D4091-1	Lug	PO 19194
200	D2230-1	Mounting Lug	PO 19194
100	D2230-3	Mounting Lug	PO 19194

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, March 7, 2013